

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004141**Date Inspected:** 30-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Keng Chan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the tower and OBG.

Bay 4**Double Diaphragm Assembly 33meter**

The Quality Assurance Inspector observed ZPMC Caltrans approved welder 049769, utilizing the flux cored arc welding process on a partial penetration joint, weld number WSDI SA-318 B/B-8. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-3514.

The Quality Assurance Inspector observed ZPMC personnel in process of performing fit up operations on diaphragm to flange assemblies.

The Quality Assurance Inspector observed ZPMC personnel in process of performing thermal cutting on diaphragm plate # SA 411.

Bay 7**Floor Beam Assembly**

WELDING INSPECTION REPORT

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The Quality Assurance Inspector observed ZPMC Caltrans approved welder 06675, utilizing the flux cored arc welding process on a complete joint penetration, weld number FB013-019-002. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U2-F-1.

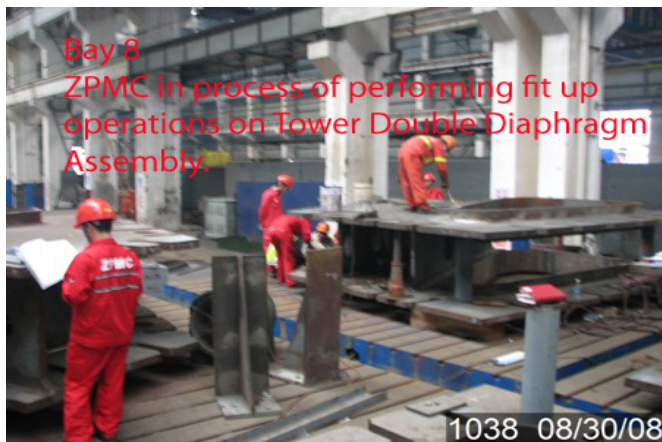
The Quality Assurance Inspector observed ZPMC personnel in process of performing thermal cutting on floor beam assemblies.

Bay 8

Floor Beam Assembly

The Quality Assurance Inspector observed ZPMC Caltrans approved welder 045240, utilizing the flux cored arc welding process on a complete joint penetration, weld number WSDI SA-309-8B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2232-B-U2-F-1.

The Quality Assurance Inspector observed ZPMC performing fit up operations on various double diaphragm assemblies.



Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer
